

5/42

Asg 143

DART AEROSPACE LTD	Work Order:	24345
Description: Bracket	Part Number:	D3156-1
Dwg: D3156 Rev. B	Qty:	12 6
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	<i>[Signature]</i>	05.09.26	10
2	MV	Cut blank: 1.950" x 0.700" grain along 1.950" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3156-1 Batch: <u>M17225</u>	<i>ml</i>	05/10/27	12
3	MV GA	Machine as per Folio FA477 and Dwg D3156 Stack of 10 Identify as D3156-1	<i>ml</i>	05/10/27	12 6 P40
4	QC2	Inspect parts as they come off the CNC machine			
5	QC8	Second check			
6	GA	Deburr	<i>ml</i>	05/10/27	12 6
7	GA	Form as per Dwg D3156	<i>ml</i>	05/10/27	12 6
8	QC5	Inspect work to Step 7	<i>PF</i>	05/11/03	6
9	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>ml</i>	05/11/03	6
10	QC3	Inspect Chemical Conversion Coat	<i>SB</i>	05/11/03	6
11	ST	Identify with part number and batch number using fine point permanent ink marker, and Stock	<i>ml</i>	05/11/03	6
12	AC	Cost / part: <u>15.64</u>	<i>54</i>	05-11-10	6
13	DC	Close W/O <u>10.97</u> Inspect Level 21	<i>[Signature]</i>	05/11/07	10

Rev	Date	Change	Revised By	Approved
A	04.11.30	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/31	7	Bad dimension of holes and band	VB 05/11/07	Scrap 12 pieces of D 3156-1 Replace by 6 pieces	ml 05/10/31	VB 05-11-07	VB 05/11/07	VB 05-11-07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/11/07

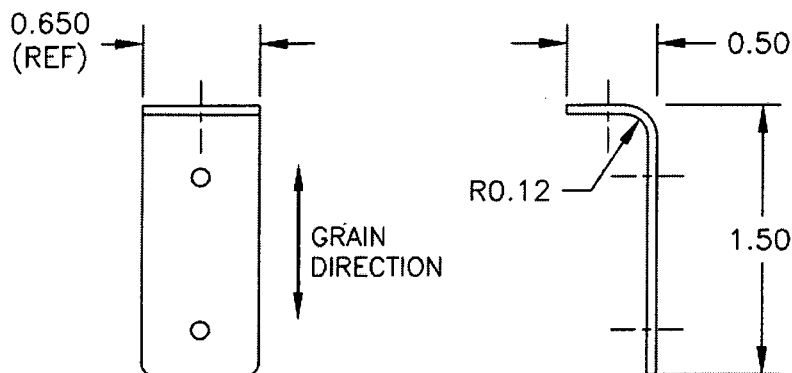
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

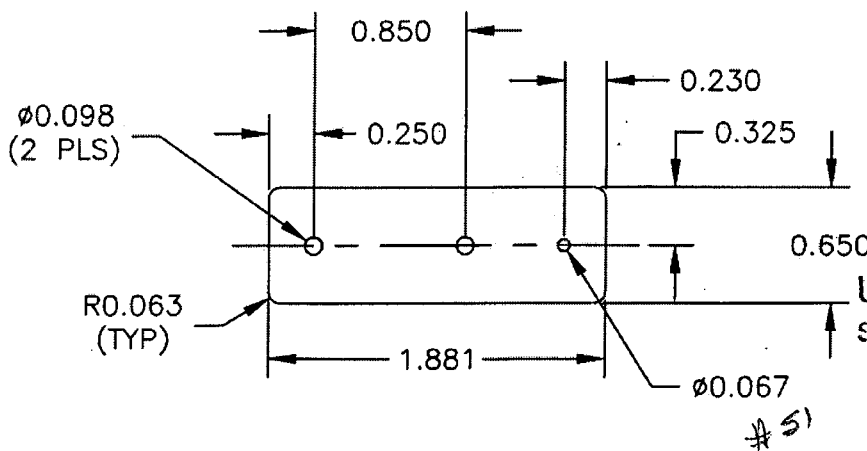


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3156	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.13



D3156-1 BRACKET



D3156-1 BRACKET FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 24345

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-117
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024345
Project Name : D3156-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3156-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:44 am

Work Order No : 0024345
Project Name : D3156-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3156-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	5.50	100.00		
Production Cost :	0.00	93.44	100.00	0.00	93.44
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	93.44	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	93.44			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-93.44)